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Work Order ID 151721

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151721

Page 1

Item ID: D2282-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube

Start Date: 10/5/2016 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 10/14/2016 Req'd Qty: 60.00 ***60*** Customer:

Reference:

Approvals: Process Plan:  Date: 10-10-11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100	DOOSAN LATHE	0.00							
100									
Doosan	Memo	0.83							
Doosan Lathe	1-Turn as per Dwg D2282 and Folio FA189								
	2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.10							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.20							
Quality Control									

60 0 16-11-6

60 0 16-11-6

60 0 DAS 20 9-89 16-11-07

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Item ID: D2282-5 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Tube
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Required Date: 10/14/2016 Req'd Qty: 60.00 ***60*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/A01</u> Memo *****STOCK IN LARGE FAB***** LOCATION : WA002	0.00 0.10				<u>60</u>	<u>0</u>	<u>16-11-7</u>	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00							<u>16/11/8</u> <u>JD</u> <u>16-11-07</u>

Picklist Print

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Parent Item: D2282-5

D2282-5

Parent Item Name: Tube

Start Date: 10/5/2016

Required Date: 10/14/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPR Rev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased		No		100	f	37.0870	0.18006	11.37221			

M304RO 750

304 SS Roundbar .750

SL 16-11-6

Location

Loc Qty

Loc Code

MAT

12.67

M135512

12.67

MAT029

24.417

135275

0.417

M135779

24

4

8

DART AEROSPACE LTD		Work Order: 151721
Description: Handle Tube		Part Number: D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.170	✓		vern	2.170
R0.063	+/-0.010	R.063	✓			
0.063	+/-0.010	.063	✓			
0.125	+/-0.010	.125	✓			
0.090 x 45°	+/-0.010	.09x45°	✓			
R0.350	+0.010/-0.000	R.350	✓			
0.158	+/-0.010	.155	✓			
Ø0.386	+0.005/-0.000	.386	✓			
Ø0.700	+/-0.010	.700	✓			

DAS
20
9-89

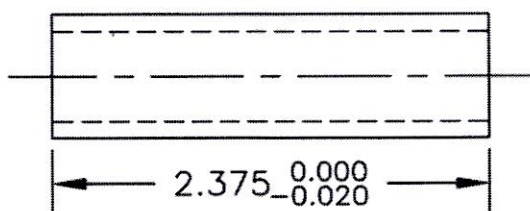
Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 16-11-6	Date: 16-11-07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	[Signature]

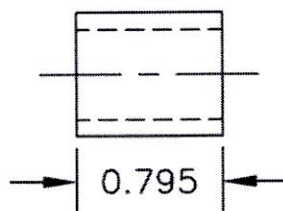


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

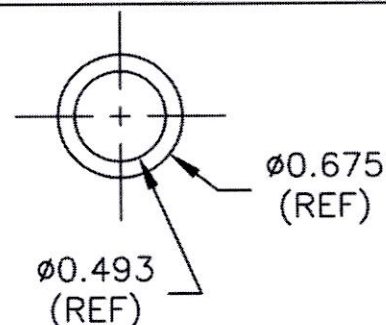
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05/09/16



D2282-3

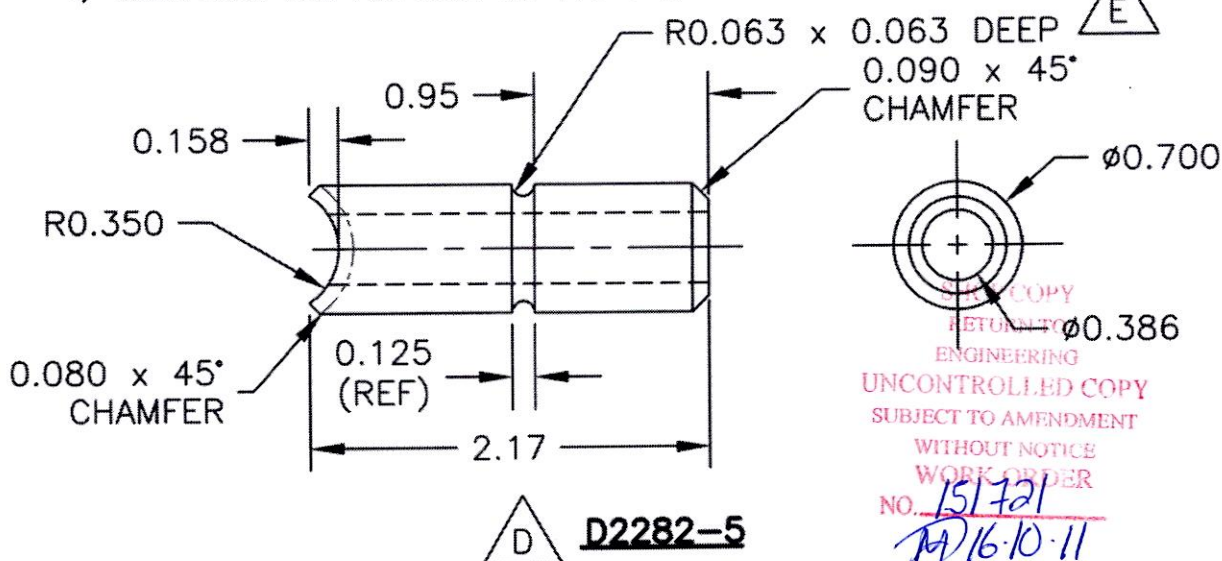


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

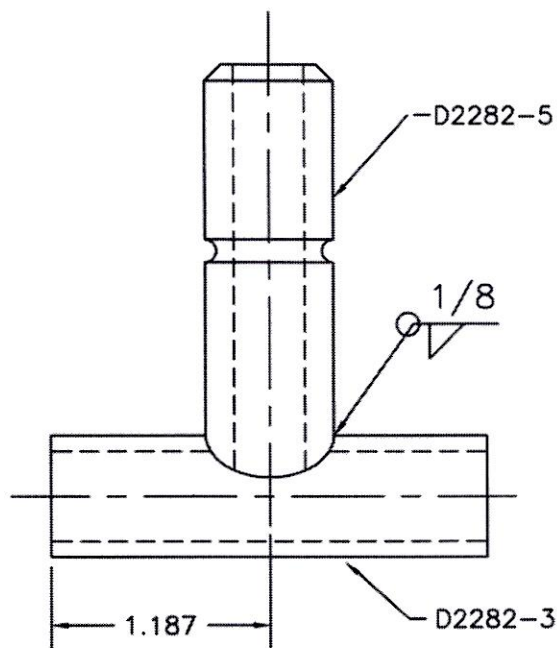


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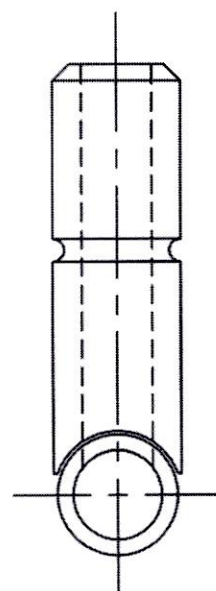
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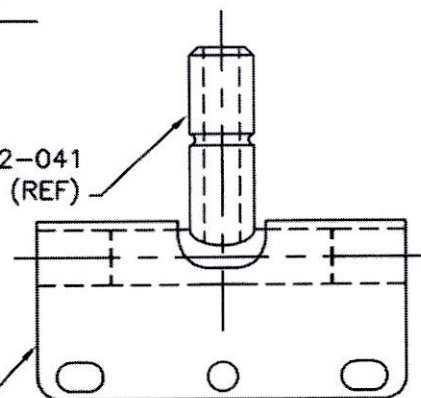
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

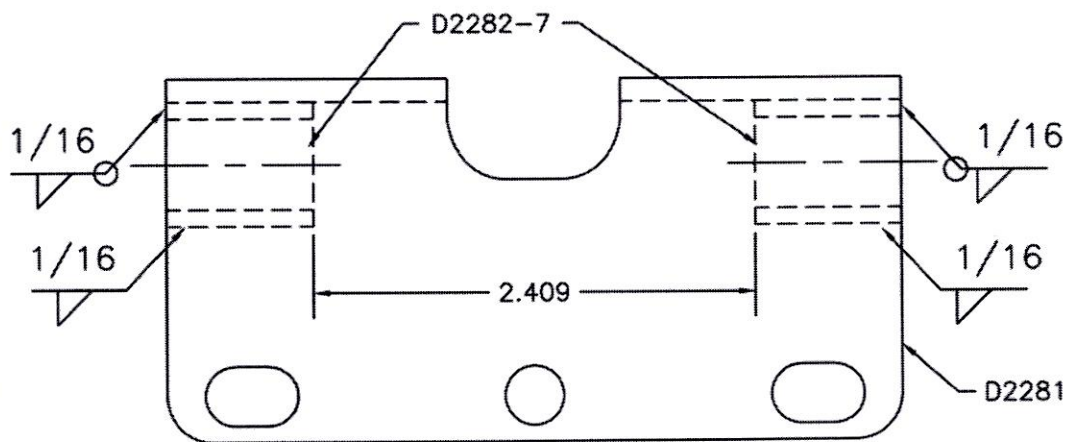


D2282-041
(REF)



D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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